

Work Order ID 51447

August 24, 2009 2:28:42 PM



Page 1

Item ID: D3641-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Cover

Start Date: 8/25/09 Start Qty: 10.00



Cust Item ID:

Required Date: 8/31/09 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Handwritten signature

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3641

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3641 Dwg Rev: B Prog Rev: B 12-
Deburr if necessary

15

HB 9-8-17

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

HB 9-8-17

15

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

27 8 08/08/25

415

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Form as per Dwg D3641-1

0.00

0.00

8/29/08/27

15

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

2/8/08/27

15

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

Memo

0.00

0.00

2/8/08/27

15

W/O:		WORK ORDER CHANGES					
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Page 3

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Setup Start



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Stop



Item Name: Cover

Start Date: 8/25/09

Start Qty: 10.00



Cust Item ID:

Required Date: 8/31/09

Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

10/08-27 (15)

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location *260*

0.00



Packaging

Memo

0.00

Packaging

9/8/08 (15X) SD

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*09/08/31 (15)**09-8-28 (15)*

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

August 24, 2009 2:28:42 PM

Page 1

Work Order ID: 51447

Parent Item: D3641-1 RevB

Parent Item Name: Cover

Comments:

Start Date: 8/25/09

Required Date: 8/31/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S-032 <i>M5052 HB2</i>		Purchased	No			100	sf	72.6500	8.2642			



~~6061 F6 Sheet 0.032"~~

M5052 HB2 9-14-08-25

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
MAT	72.65	
110063	9.26	
16954	8.99	
18375	54.4	

111448

HB 9-8-17

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	51447
Description: COVER		Part Number:	D3641-1
Inspection Dwg: D3641-1 Rev: B		Page 1 of 1	

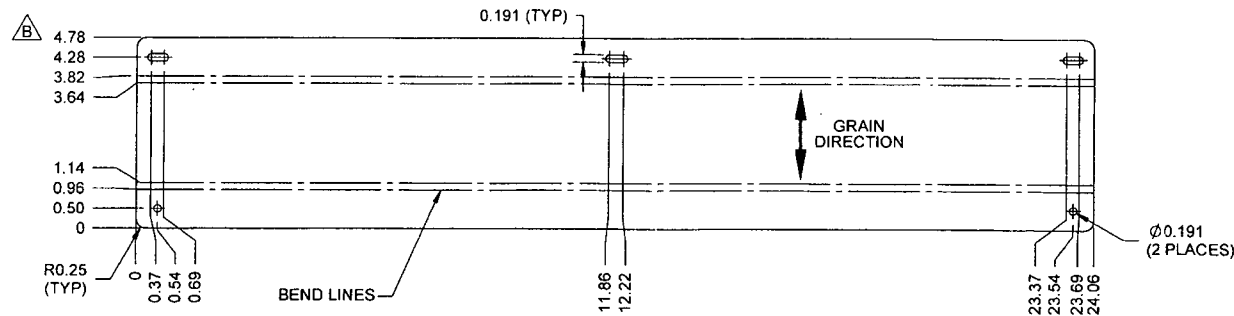
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

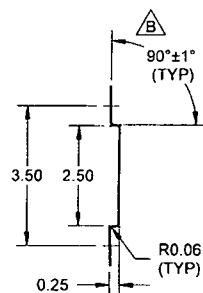
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.191	+ .005 - .001	.193	X			
.191	+/- .010	.193	X			
.37	+/- .030	.371	>			
.54	+/- .030	.535	X			
.69	+/- .030	.693	X			
11.86	+/- .030	11.864	✓			
12.22	+/- .030	12.22	✓			
23.37	+/- .030	23.375	X			
23.54	+/- .030	23.54	✓			
23.69	+/- .030	23.69	X			
24.06	+/- .030	24.06	X			
.50	+/- .030	.500	X			
4.28	+/- .030	4.293	X			
4.78	+/- .030	4.791	X			
.032	+/- .010	.031	X			

Measured by: RB	Audited by: SJ	Prototype Approval: 1/9
Date: 9-8-17	Date: 09/08/25	Date: 1/9

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3641-1F FLAT PATTERN



**D3641-1 COVER
(REPLACES GENEVA P/N G10606-3/-6)**

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM 0.032 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.35 lbs

W051447

draw shows wrong 1-3 reversed

UNDER REVIEW

AJS 0723

See AJS 0706

See ECM 09-635

OK for -1 only

RA 09.08.23

RELEASED

10-7-14/100

B	UPDATE PROFILE TO MATCH TOOLING; GENERAL UPDATE	LE	07.10.16
A	NEW ISSUE; REPLACES G10606	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS		
DRAWN	LE		
CHECKED	RA		
MFG. APPR.	LS		
APPROVED	RA		
DE APPR.	SH		
DATE	07.10.16		

DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. B
DRAWING NO. D3641	SHEET 1 OF 2
TITLE COVER	SCALE 1:3

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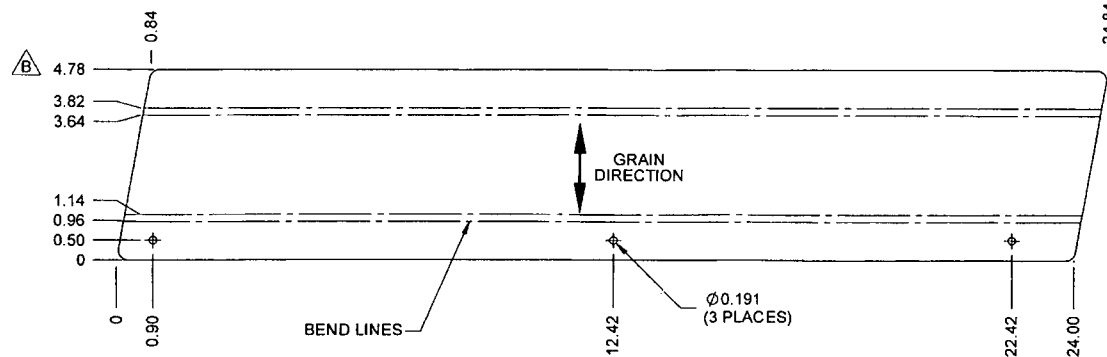
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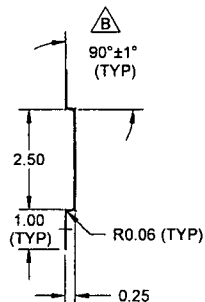
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NOTE: Date & initial all entries



D3641-3F FLAT PATTERN



D3641-3 COVER
 (REPLACES GENEVA P/N G10606-5)
D3641-4 OPPOSITE
 (REPLACES GENEVA P/N G10606-4)

UNDER REVIEW

ADS 09.07.23
 See NCR 09-076
 See ELN 09-635

RELEASED
 07.11.14

NOTES:

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- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-3/-4" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.36 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	UE	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	PH	D3641	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	COVER	1:3
DATE	07.10.16	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC.	
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